

Work Order ID 66044

Thursday, February 03, 2011 7:34:44 AM

Page 1

Item ID: D3414-041

Accept

Revision ID:

Item Name: Lug Assembly

Setup Start

Stop

Start Date: 2/3/2011 Start Qty: 10.00

Required Date: 2/8/2011 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *CMF*

Date: *11-02-03* Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3414

Rev C

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3414-1

Dwg Rev: *E*

Prog Rev: *E*

2-Deburr if necessary

B11-2-7

(10)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-2-7

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

0.00



Brake NC

Memo

0.00

Brake NC

1-Deburr
2-Form using DT8254 as per Dwg D3414

140

0.00



Large Fab

Memo

0.00

Large Fab

1- Weld using location Jig DT9625 as per Dwg D3414
A/R S.S. welding rod Batch: M107037

Subtotal

SPB 11/02/08

EL 11-2-24

(10)

(10)

(10)

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

150



QC

Quality Control

Operation
Description

QC9- Inspect visual per QS1004- Fusion Welds

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

11-02-28

11-02-28

11-02-28

(100)

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

11-02-28

(110)

170



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

M115951-

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:30
7000
2:50

0.00

0.00

10 BR 11-2-28

Work Order ID 66044

Thursday, February 03, 2011 7:34:44 AM

Page 4

Item ID: D3414-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Lug Assembly

Start Date: 2/3/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 2/8/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

⇒ m-h 11/02/28

10X

190

Identify as per dwg & Stock Location 473

0.00

Packaging

Memo

0.00

Packaging

11/02/28

200

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/03/01

CL11/03/01

Picklist Print

Thursday, February 03, 2011 7:34:41 AM

Page 1

Work Order ID: 66044

Parent Item: D3414-041

Parent Item Name: Lug Assembly



Start Date: 2/3/2011

Required Date: 2/8/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A: 05.09.13: (New issue: (KJ/JLM:)

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S12GA		Purchased	No			100	sf	193.1000	0.155	1.55			



304/316 0.100" Sheet



11-2-7

Location

Loc Qty

Loc Code

MAT19

193.1

112290

4.1

112611

29

113062

128

113077

32

112290

(10)

D3414-3

Manufactured

No

140

Each

0.0000

1

10



Lug

66045 x 10

EL 11-2-24

DART AEROSPACE LTD		Work Order:	66044
Description: Lug Bracket		Part Number:	D3414-1
Inspection Dwg: D3414	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

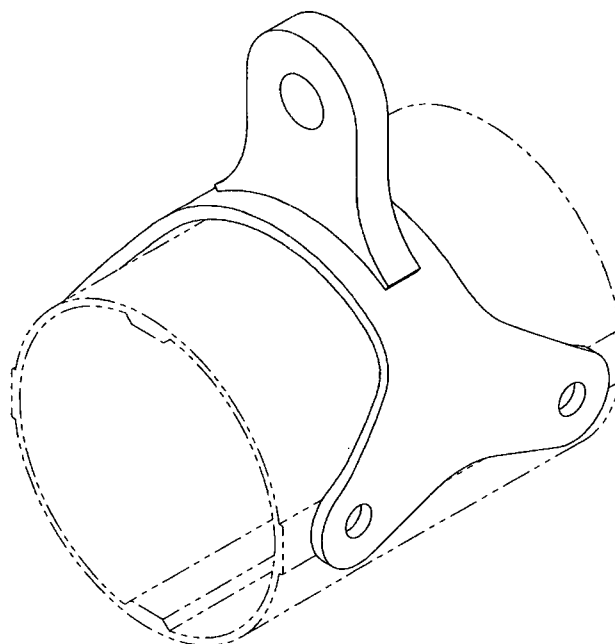
☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.313	+0.006/-0.001	.314	✓		✓ 1B2	
1.19	+/-0.030	1.182	✓		✓	
1.00	+/-0.030	1.008	✓		✓	
3.38	+/-0.030	3.370	✓		✓	
5.350	+/-0.010	5.353	✓		✓	
6.23	+/-0.030	6.226	✓		✓	
2.500	+/-0.010	2.497	✓		✓	
0.37	+/-0.030	.365	✓		✓	
0.100	+/-0.010	.099	✓		✓	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-2-7	Date: 11/02/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue P/O D3414-041	KJ/DD	
B	09.05.27	Dimensions updated per Dwg Rev B	KJ	
C	09.10.16	Dwg Rev updated to Rev C	KJ	

ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG



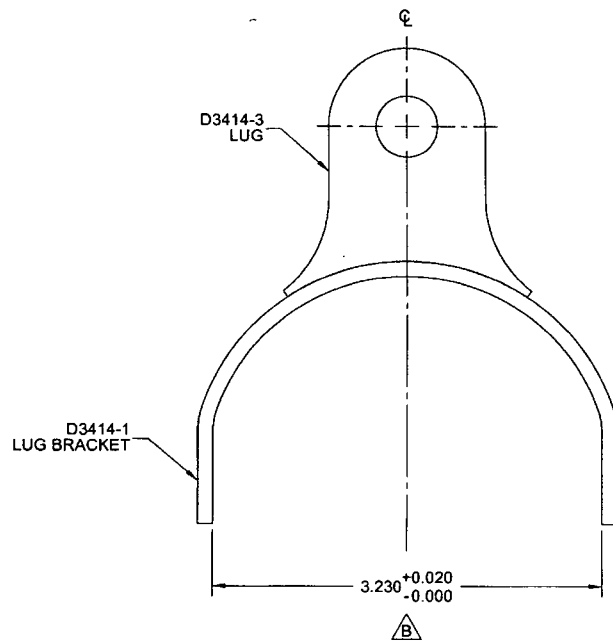
D3414-041 LUG ASSEMBLY

NOTES:

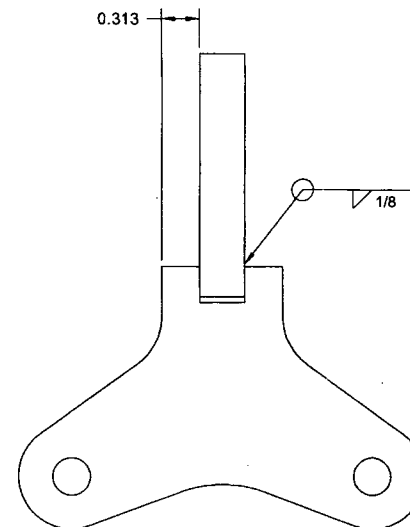
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

RELEASED
09/06/17

C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD	
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
DATE	09.06.17	COPYRIGHT © 2025 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



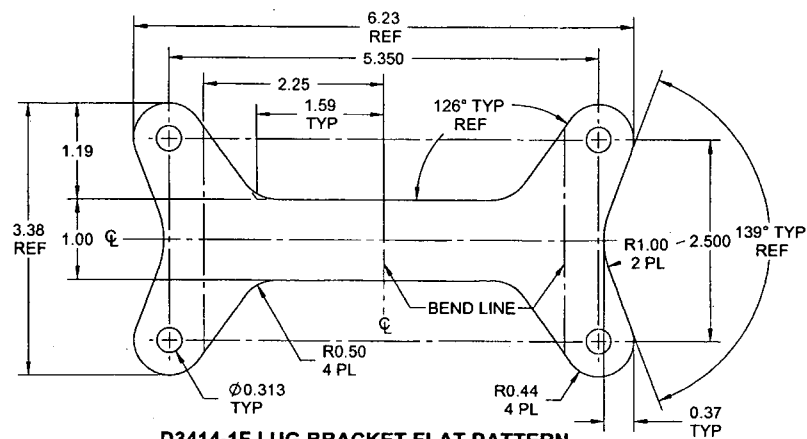
D3414-041 LUG ASSEMBLY



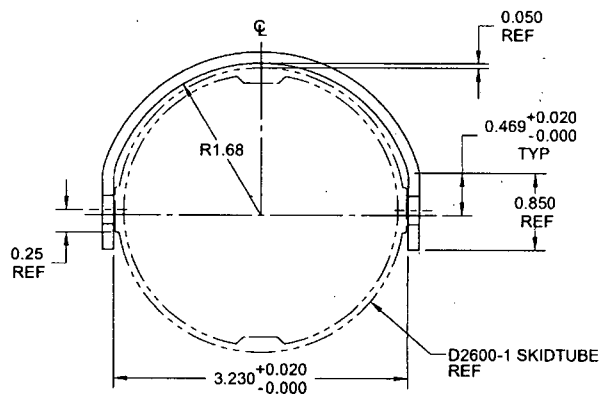
66044

RELEASED
09/18/17

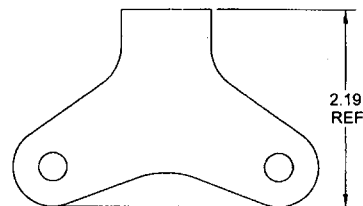
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
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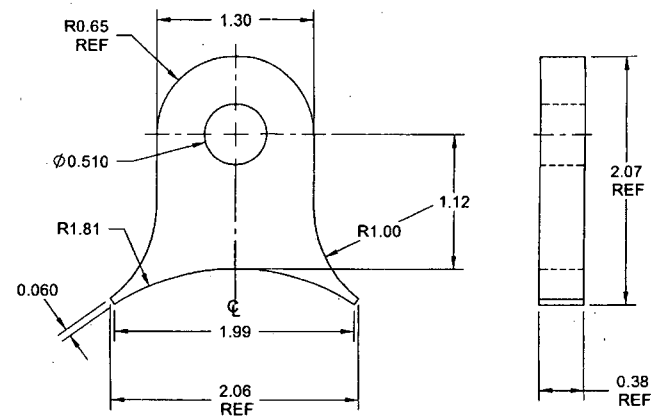
D3414-1F LUG BRACKET FLAT PATTERN



D3414-1 LUG BRACKET



SIDE VIEW FOR REF ONLY



D3414-3 LUG

NOTES:

1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S12GA

-3: AISI 304/316 STAINLESS STEEL PLATE
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX
-3: 0.030 TO 0.060 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: N/A

RELEASED
28/06/06

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3414	REV. C
MFG. APPR.		SHEET 3 OF 3	
APPROVED		TITLE LUG ASSEMBLY	SCALE
DE APPR.		NTS	
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